

Work Order ID 73912

Monday, September 19, 2011 10:07:08 AM



Page 1

Item ID: D3822-1KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, LH-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 1-09-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3822-1	Rev. C								

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

Wh

11/12/21

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 4:00 pm 11/12/20

Time OUT: 2:00 am 11/12/21

x2

Wh

11/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA025 using tool DT9073
Dwg Rev: 5
Folio Rev: 5

x2

Dh
11/12/21

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x2

Dh
11/12/21

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Sum 12/23

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Required Date: 9/23/2011 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 		0.00							
HandThermo	Memo	0.00				x2			DL 11/12/22
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x2			DL 11/12/22
Quality Control	Complete FAI document								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				8			11/12/23
Quality Control						(12)			

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Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 1S2

0.00



Packaging

Memo

0.00

Packaging

11/12/29 SL/2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 12/01/0211-12-29
(2)

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Picklist Print

Page 1

Monday, September 19, 2011 10:07:05 AM

Work Order ID: 73912



Parent Item: D3822-1KGY



Parent Item Name: Vertical Tunnel, LH-Grey

Start Date: 9/19/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MKYD6185S.080-P3-
52068

Purchased

No

100

sf

436.3796

7.8

15.60780



Kydex steel grey

Location

Loc Qty

Loc Code

therm

436.3796282

436.379628

111807

119476

15.60780 sq ft.

Sh
11/12/22

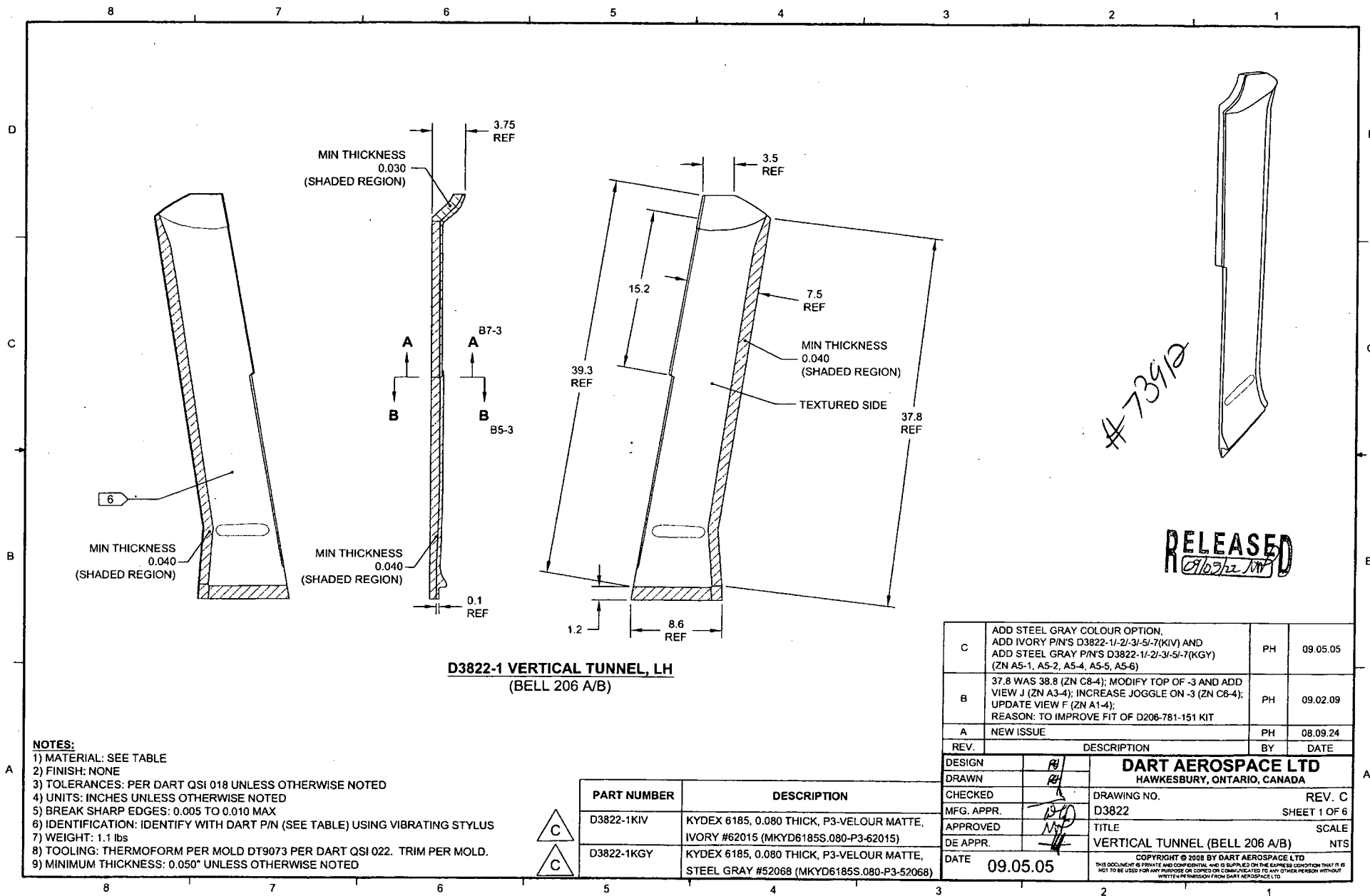
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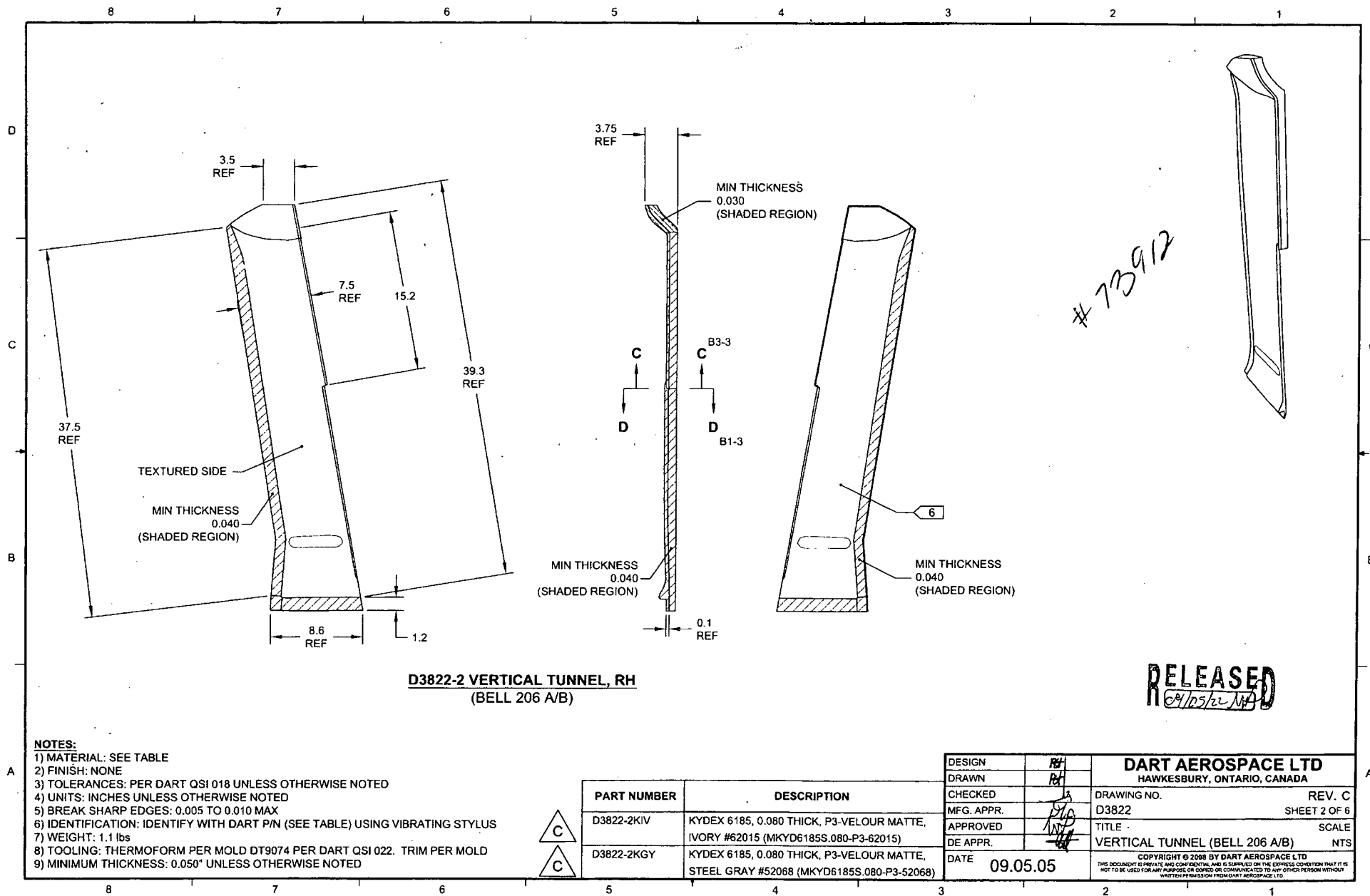
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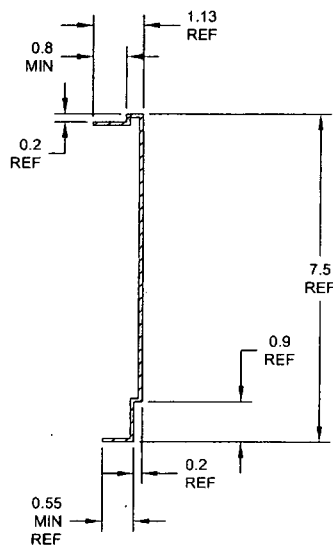
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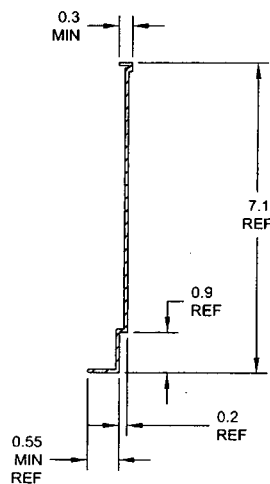
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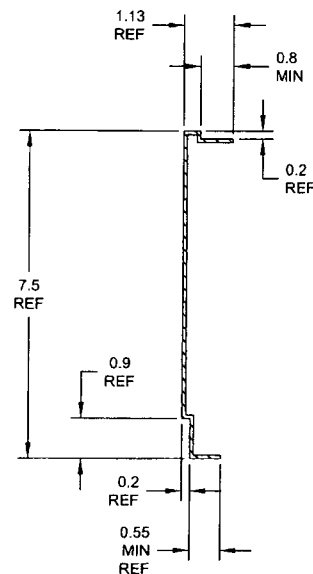
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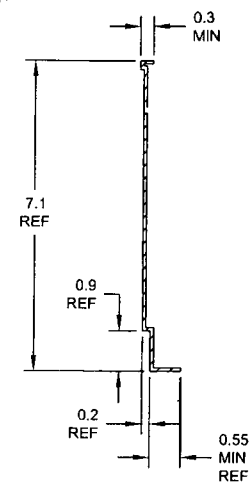
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

RELEASED
09/05/05

DESIGN	RA	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D3822	REV. C
MFG. APPR.	JP	SHEET 3 OF 6	
APPROVED	JP	SCALE	
DE APPR.	JP	VERTICAL TUNNEL (BELL 206 A/B) NTS	
DATE	09.05.05	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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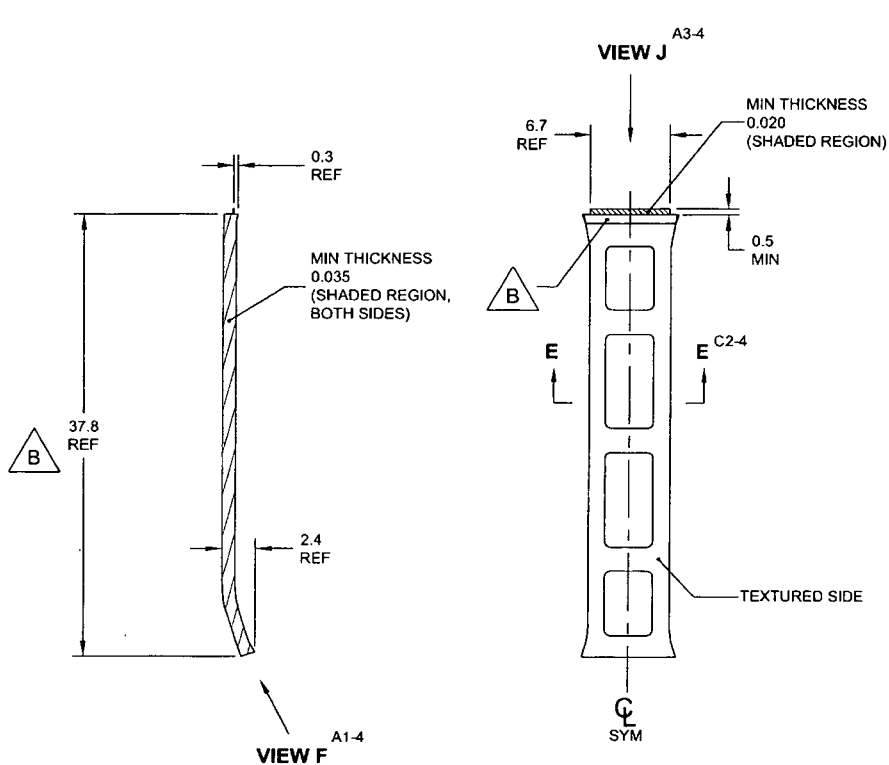
NOTE: Date & initial all entries

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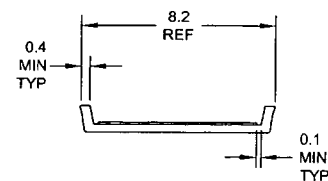
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C

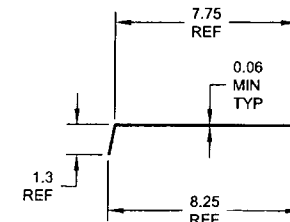
B



D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)



VIEW J
SCALE 2X



VIEW F
SCALE 2X
(ROTATED 90° CW)

RELEASED
09/05/05

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 4 OF 6
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

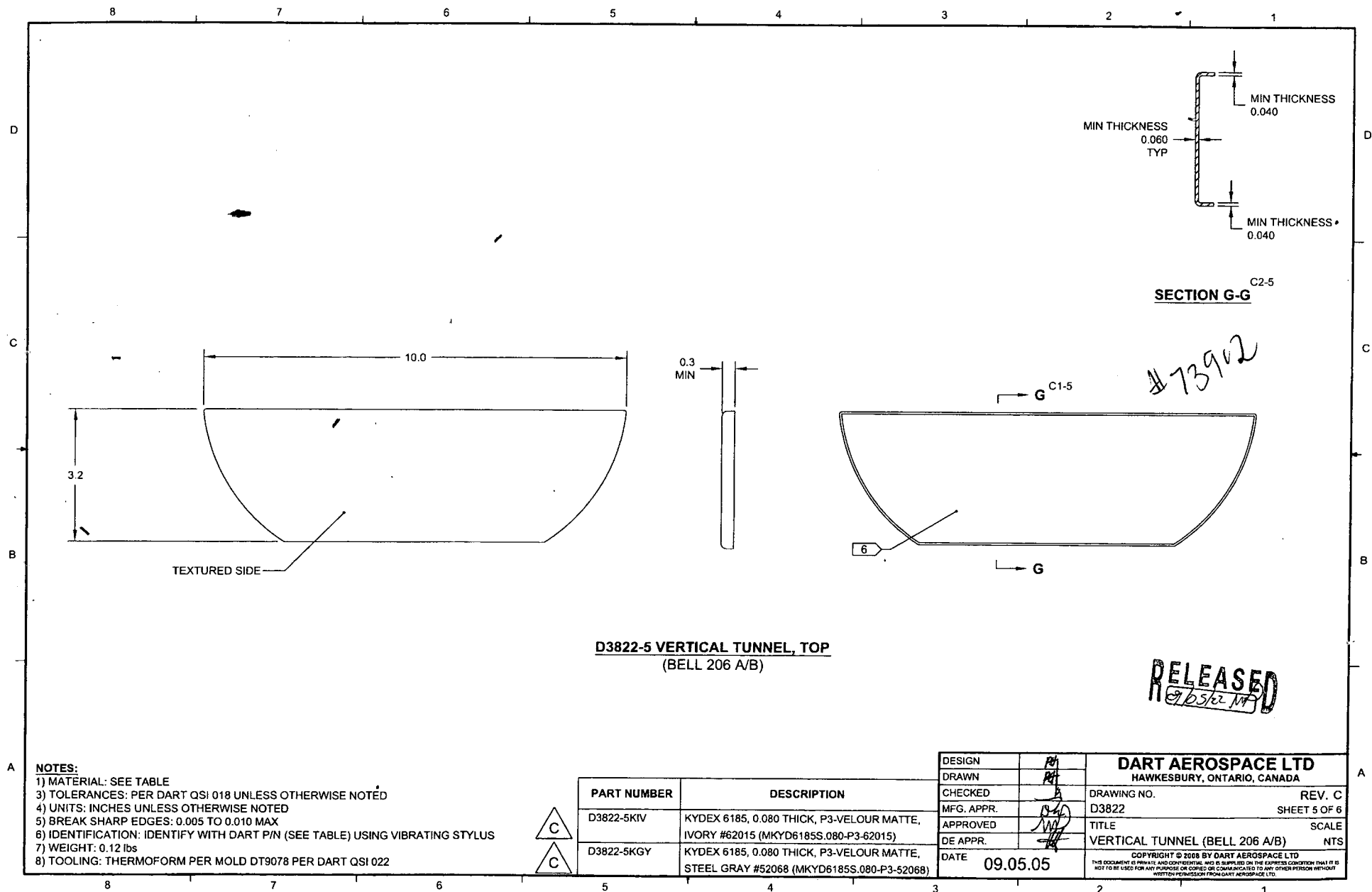
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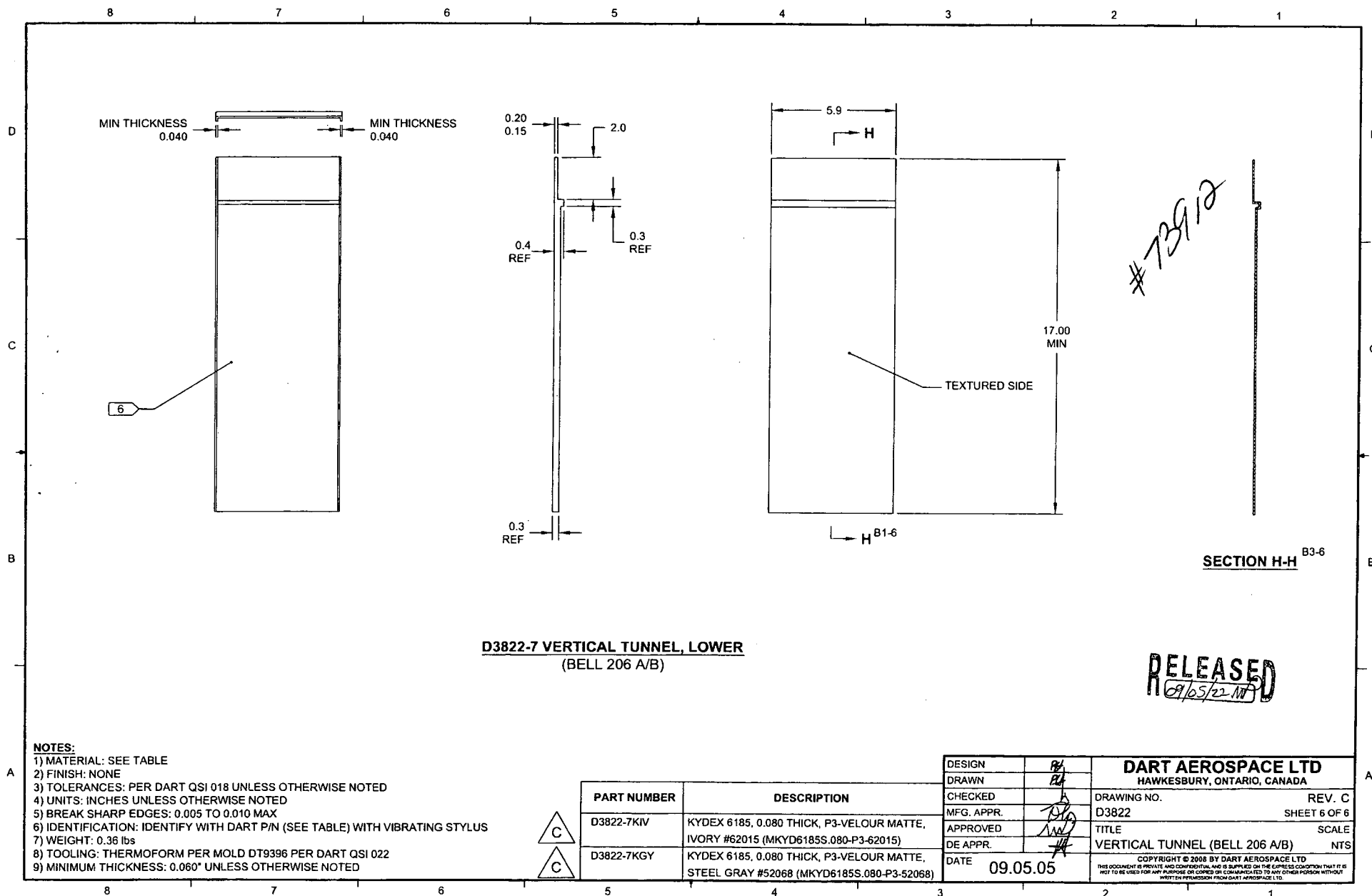
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DART AEROSPACE LTD		Work Order: 73812
Description: Vertical Tunnel, LH		Part Number: D3822-1KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DR

Date: 11/13/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	0.978"	✓		Ugn DL-02	
0.3	Min	0.352"	✓		Ugn DL-02	
0.55	Min	0.77"	✓		Ugn DL-02	
0.040	Min	0.060"	✓		Ugn DL-02	
0.050	Min	0.068"			CAL TH-01	

Measured by: DR

Date: 11/12/22

Audited by: S

Date: 4/12/23

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<u>[Signature]</u>